

Date: Tuesday, 8/14/2007 6:31:07 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET, GAS SPRING STUD
Job Number	: 33886		
Estimate Number	: 10183		
P.O. Number	: N/A	Part Number	: D2154
This Issue	: 8/14/2007 S.O. No. : N/A	Drawing Number	: D2154 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31688	Material	: N/A
Written By	: <u>07-08-14</u>	Due Date	: 8/21/2007 Qty: 50 Um: Each
Checked & Approved By	:		
Comment	: Est: C 03.08.08 Reformat; Remove Tumble KJ/RF Est Rev:D NowOn Waterjet 07-04-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0350 sf(s)/Unit Total : 1.7483 sf(s)

304/316 .063 Sheet

Batch: M10S130 B 07-08-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2154

Dwg Rev: C

Prog Rev: C

B 07-08-14

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 07-08-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

See 07/08/14 (X57) coated

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

dm 07/08/14 (57)

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 33886

Part Number: D2154

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Form as per Dwg D2154 Rev: C

SB 07/08/21

(57)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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control

Comment: INSPECT WORK TO CURRENT STEP

Er 01/08/22 (57)

8.0	POWDER COATING	POWDER COATING
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M105068

(57x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

m-k 07/08/29

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

07/08/30 (57)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/08/30 (57x)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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(57)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/31

Job Completion

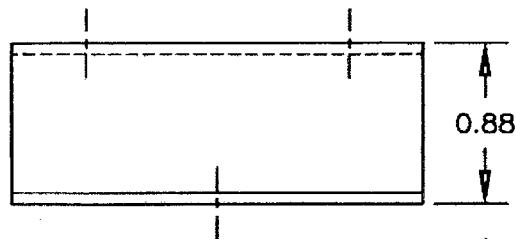


U 07.08.31

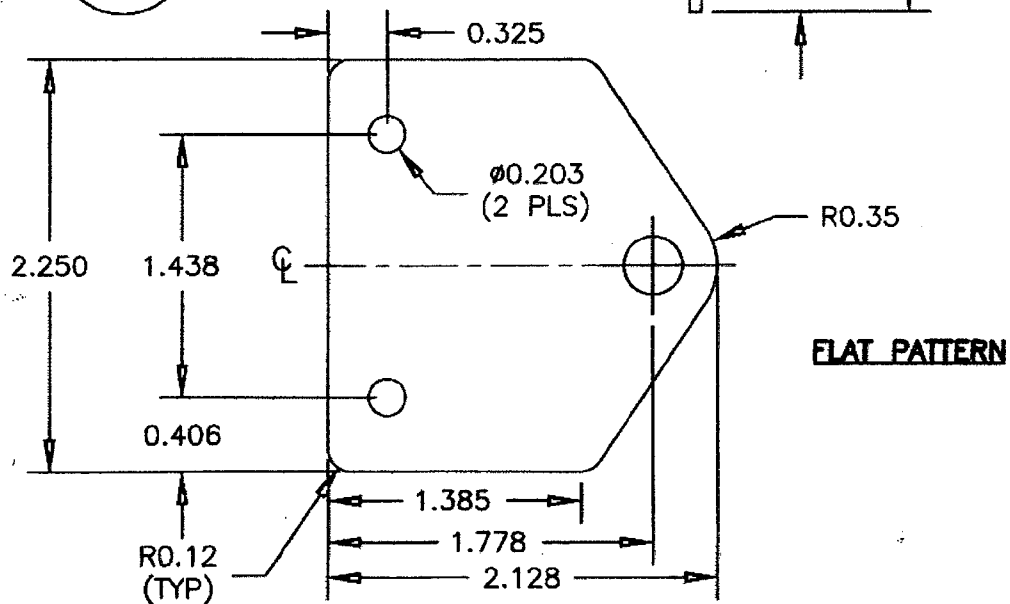
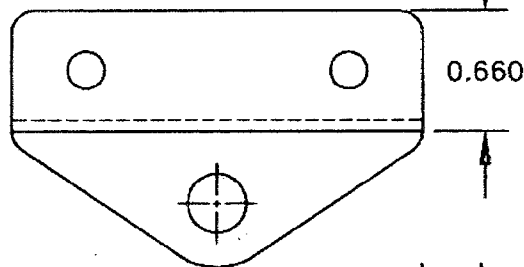
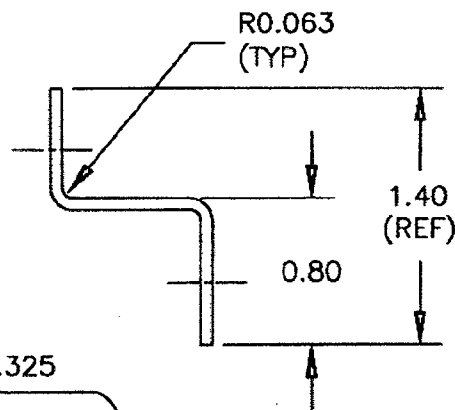


DESIGN GH	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12		TITLE BRACKET, STUD	SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED  
04.10.15



### BEND DETAIL



### FLAT PATTERN

#### D2154 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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